

Date: Tuesday, 10/06/2008 3:33:53 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 206 A/B LOW GEAR WEB		
Job Number	: 39813			Part Number	: D26541		
Estimate Number	: 11768			Drawing Number	: D2654 REV D E1		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/06/2008 S.O. No. :			Drawing Revision	: E1 10/06/10		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SKIDTUBES			Due Date	: 17/06/2008 Qty: 1 Um: Each		
Previous Run	:			Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM		
Written By	:			Checked & Approved By	: JUL 08-6-10		
Comment	:			Comment	:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D26005108	Extrusion 'I Beam' thin		
		 <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2600-5 Web B2998S D 11 8-6-17		
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1		
		 <b>Comment:</b> LANDING GEAR RESOURCE 1 1-Cut D2600-5 to length as per Dwg D2654 (73.85") 2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654 3-Using the uni-bit, open holes to finish size as per Dwg D2654 4-Deburr holes and ends		
3.0	QC5	INSPECT WORK TO CURRENT STEP		
		 <b>Comment:</b> INSPECT WORK TO CURRENT STEP		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		
		 <b>Comment:</b> HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 3:33:54 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B LOW GEAR WEB

Job Number: 39813

Part Number: D26541

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

25 08-06-20

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: L.G.

① M 8-6-20

7.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/2008

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



cmf 08-06-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

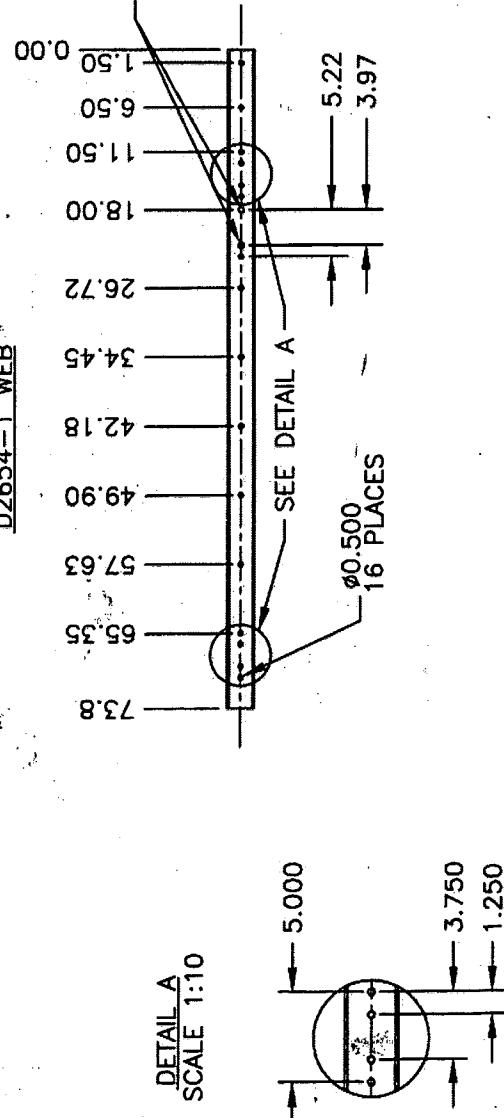
**DART**

COPY ISSUE

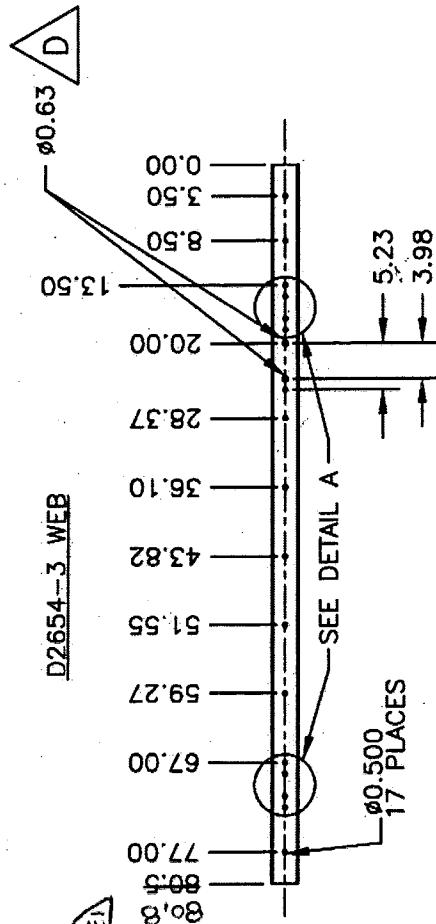
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO.	PORT HADLOCK, WA
DATE		TITLE	REV. E
04.05.26		WEB	SHEET 1 OF 2
			SCALE
			1:20

**RELEASED**  
04.06.22

D2654-1 WEB



D2654-3 WEB



MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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WORK ORDER  
NO. 3781

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

**DART**COPY  
SUSPENDED

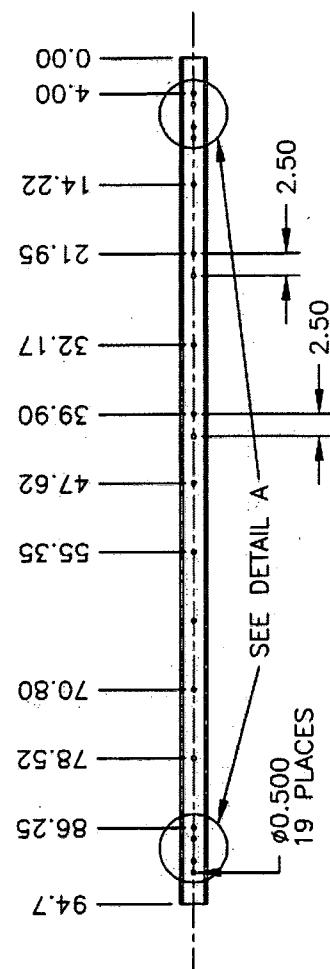
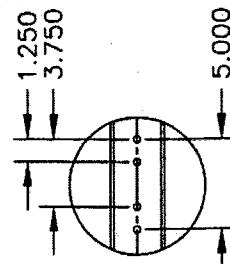
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. REV. E D2654
DATE		SHEET 2 OF 2
04.05.26		WEB

SCALE

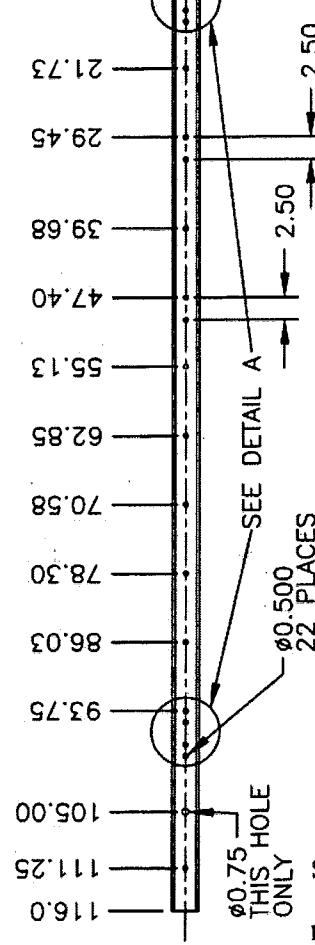
1:20

**RELEASED**  
04.06.22

D2654-5 WEB

DETAIL A  
SCALE 1:10

D2654-7 WEB



SHOP COPY  
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WORK ORDER  
NO. 39813

MAKE FROM D2600-7-125 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	B 39813
Description: D 26541	Part Number:	D 26541
Inspection Dwg: D 2654 Rev: E		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

1. 100

Measured by: <u>AK</u>	Audited by: <u>DD</u>	Prototype Approval: <u>AP</u>
Date: 8-6-20	Date: 8-6-20	Date: 08.06.20

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

